

Work Order ID 56954

March 15, 2010 1:33:14 PM



Page 1

Item ID: D3911-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud, Lower

Start Date: 16/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00



Customer:

Reference:

10.03.15

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3911

A

110

0.00



Doosan

Memo

0.00

Doosan Lathe

1-Mill as per folio FA831 & dwg,

FOLIO REV: N/A

DWG REV: A

SL 10/03/21

(8)

2-GRIND .13" RAD MANUALLY

3-Deburr as required

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/03/21

Work Order ID 56954

March 15, 2010 1:33:14 PM



Page 2

Item ID: D3911-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Installation Stud, Lower

Start Date: 16/03/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 8.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

LB 10/03/21

8 8

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 095

0.00



Packaging

Memo

0.00

Packaging

11/03/22 (8)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24 (8)

11/03/22 (4)

Picklist Print

March 15, 2010 1:33:13 PM

Page 1

Work Order ID: 56954



Parent Item: D3911-1

Parent Item Name: Basket Installation Stud, Lower

Start Date: 16/03/2010

Required Date: 26/03/2010

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			110	f	59.5700	2.1053			



303 Round Bar 1.00



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

59.57

111571

2.37

113325

57.2

2.11

JL 10/03/21

DART AEROSPACE LTD		Work Order: 56954
Description: basket instl stud		Part Number: D3911-1
Inspection Dwg: D3911	Rev: A	Page 1 of 1

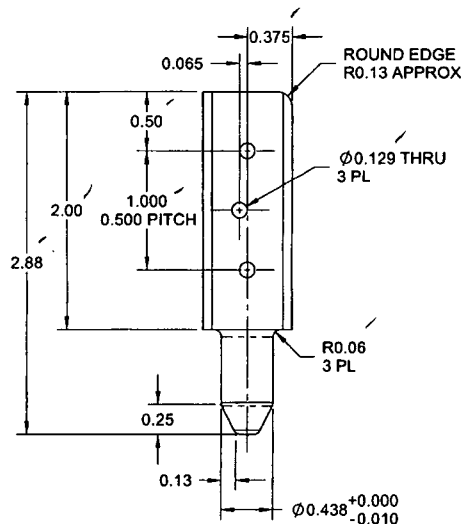
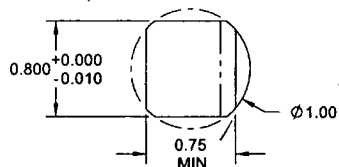
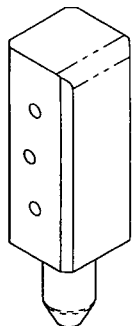
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

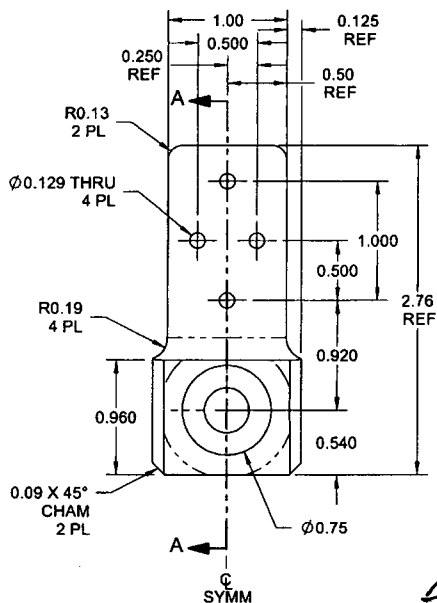
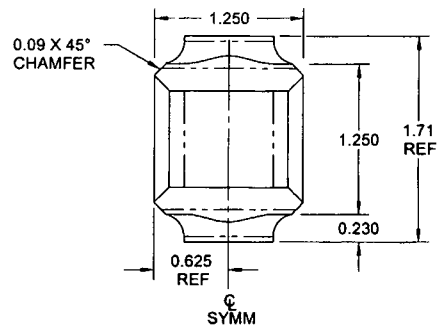
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.800	+0 -.010	.795	✓			
1.00	± .030	.998	✓			
.750	+ .030 - 0	.755	✓			
5.13	± .030	.130	✓			
.375	+ -.010	.375	✓			
6.129	+ .005 - .001	.129	✓			
.065	± .010	.066	✓			
.50	± .030	.500	✓			
1.000	± .010	1.000	✓			
.500 pitch	± .010	.500	✓			
2.00	± .030	2.002	✓			
2.88	± .030	2.881	✓			
5.06	+ - .030	.06	✓			
.25	± .030	.240	✓			
.13	± .030					
.438	+0 - .010	.437	✓			

Measured by: SL	Audited by: B.P.	Prototype Approval:	N/A
Date: 10/03/21	Date: 10/03/21	Date:	N/A

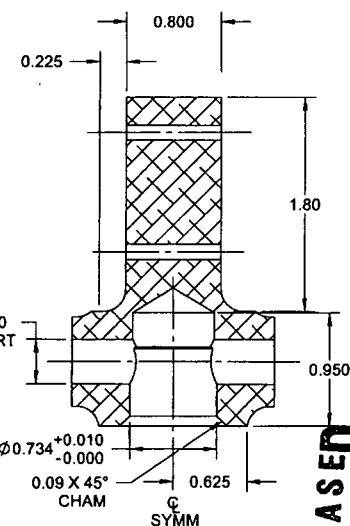
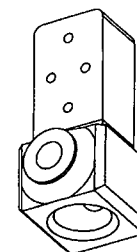
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3911-1 BASKET INSTL STUD (LOWER)



D3911-3 AFT EYEBOLT RECEIVER



DRILL & TAP
3/8-16 FOR
MS21209-C610
HELICAL INSERT
2 PL

SECTION A-A

NOTES:

- 1) MATERIAL -1: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
PER DART SPEC M303R OR M304R
- 3: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -1: 0.36 lbs
-3: 0.74 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3911	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

RELEASED
2010-03-12